

Date: Thursday, 01/05/2008 12:48:24 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 38950	
<b>Estimate Number</b> : 10178	
<b>P.O. Number</b> :	<b>Part Number</b> : D25941
<b>This Issue</b> : 01/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2594 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 37926	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/05/2008 <b>Qty:</b> 500 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.5.0</u>	
<b>Comment</b> : Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



**Comment:** Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)  
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
 1100-0 (QQ-A-225/1) Ø0.625" Rod  
 (M5052H32R0.625) or (M6061T6R0.625) Batch M106634 mmf 08/05/02

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



**Comment:** HARDINGE CNC LATHE SMALL  
 1-Make as per Dwg D2594-1 and Folio FA262.  
 2-Break all sharp edges 0.010 max. mmf 08/05/02 20 08/05/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE mmf 08/05/02 20 08/05/03 (502)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK 20 08/05/03 (502)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1 FL 08/05/06 (502)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 01/05/2008 12:48:24 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38950

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107550



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

START TIME: 3:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:30pm

MF

08-05-08 (502)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(502X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF

08/05/08

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(502X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P 1

MF

08/05/08

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

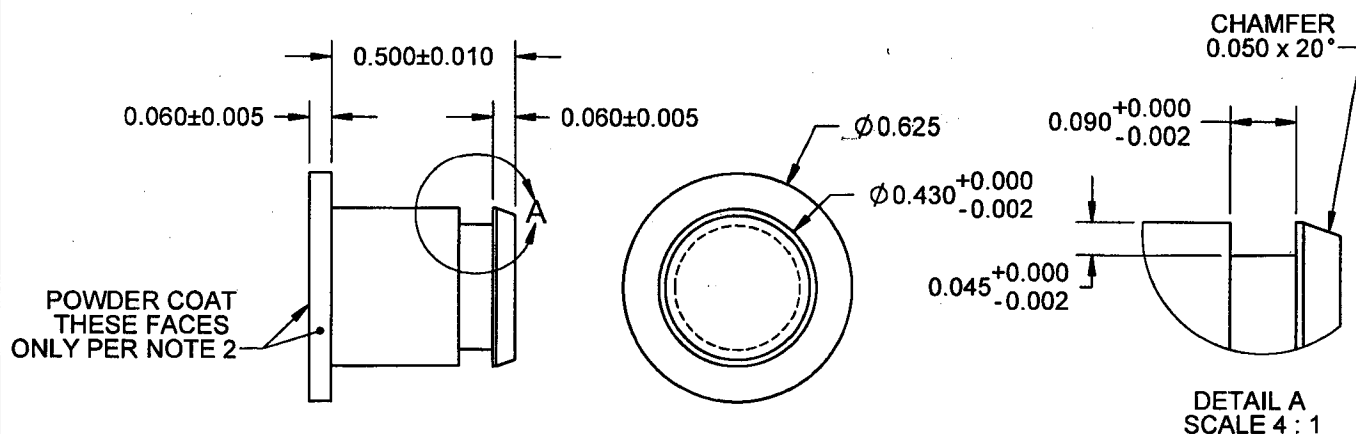
NOTE: Date & initial all entries





DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED  
06.11.28 [Signature]



**D2594-1 PLUG**

**D2594-1 PLUG NOTES:**

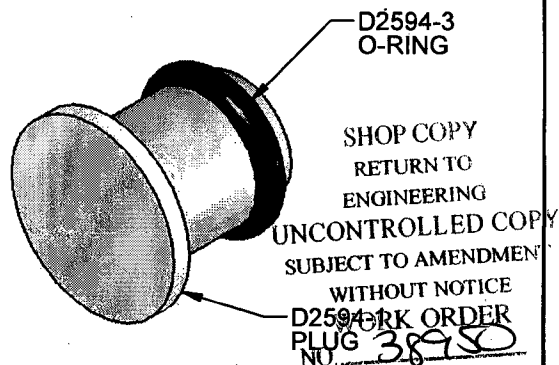
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle C$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



**D2594 PLUG ASSEMBLY**

COPYRIGHT © 1996 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.